

Work Order ID 130537

March-23-15 10:31:23 AM

647.3903

130537

Page 1

Item ID: 647.3903

Revision ID:

Item Name: Deflector Assembly

Start Date: 3/13/15 Start Qty: 2.00

Required Date: 3/13/15 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

N900040100

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
647.3900	NC3

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

DAS
41 for C.R.
9-89
15-3-31

120 0.00

120

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note.

A/R RTV LOCTITE 598: 125637
exp. date: 5/15DAS
41 for C.R.
9-89
15-3-31
→ PTO

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

0.00

Quality Control

DAS
38
9-89
MAR 31 2015

Work Order ID 130537

130537

Page 2

March-23-15 10:31:23 AM

Item ID: 647.3903 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Deflector Assembly
 Start Date: 3/13/15 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 3/13/15 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>rch 009</u>	0.00				2	DAS 27		
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MAR 31 2015

MUS 1504-01

DIS-4-1

Picklist Print

March-23-15 10:31:23 AM

Page 1

Work Order ID: 130537

Parent Item: 647.3903

Parent Item Name: Deflector Assembly

130537

647.3903

Start Date: 3/13/15

Required Date: 3/13/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.07.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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647.3915 *647.3915* Deflector		Manufactured	No				Each	24.0000		2		DAS for CR. 41 9-89 15-3-31	
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Location	Loc Qty	Loc Code
CCK056	24	
120739	8	
121791	16	

647.3916 *647.3916* Deflector		Manufactured	No				Each	1.0000		2		CR 15-03-30	
--	--	--------------	----	--	--	--	------	--------	--	---	--	-------------	--

Location	Loc Qty	Loc Code
MF	1	
121376	1	
130538		

647.3917 *647.3917* Doubler		Manufactured	No				Each	0.0000		4		DAS for CR. 41 9-89 15-3-31	
--	--	--------------	----	--	--	--	------	--------	--	---	--	-----------------------------------	--

CR3213-6-9 *CR3213-6-9* Cherry Rivet		Purchased	No				Each	82.0000		12		CR 15-03-30	
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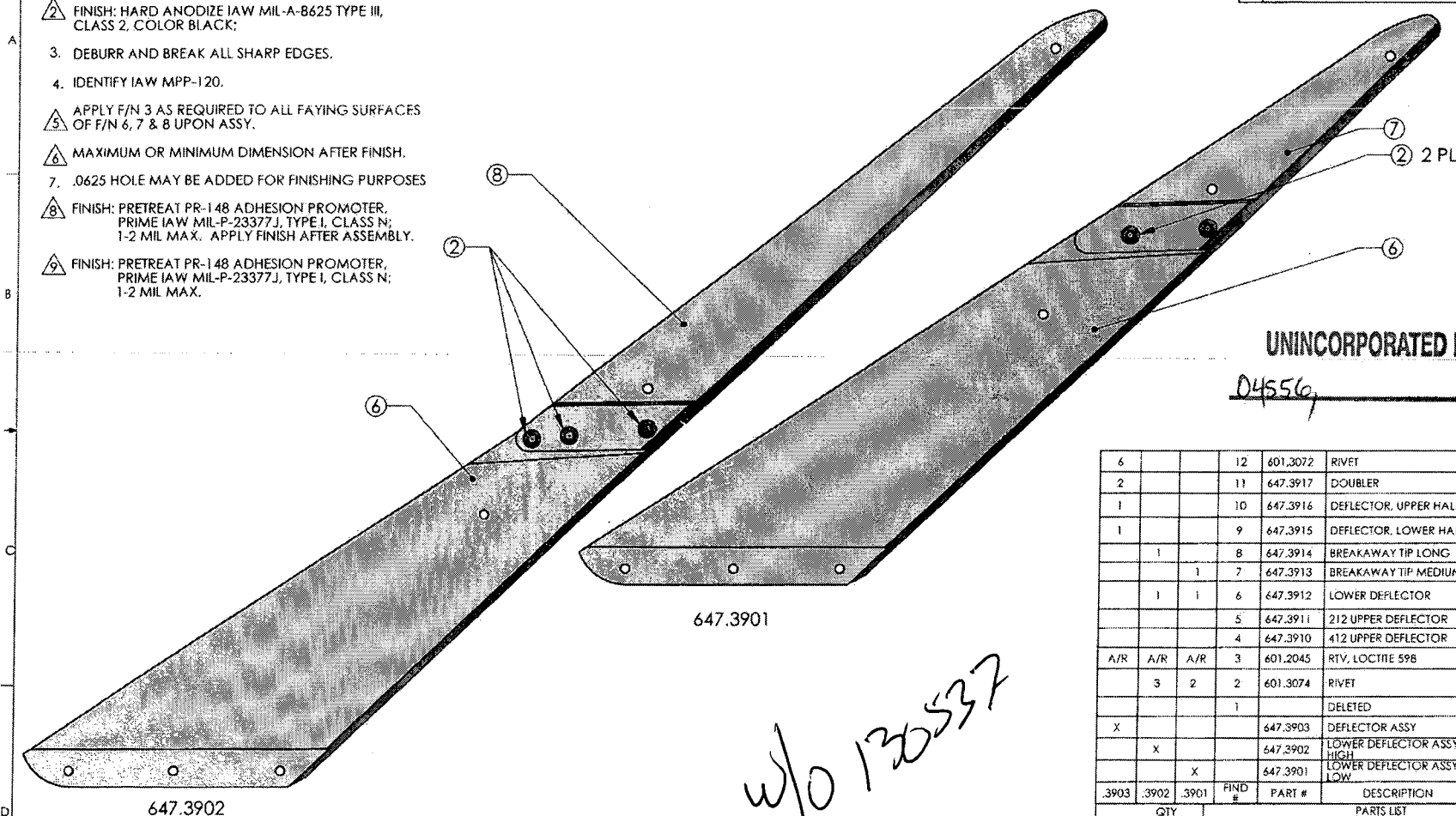
Location	Loc Qty	Loc Code
ST318	82	
131049	82	

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NOTES:

1. MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
5. APPLY F/N 3 AS REQUIRED TO ALL FAYING SURFACES OF F/N 6, 7 & 8 UPON ASSY.
6. MAXIMUM OR MINIMUM DIMENSION AFTER FINISH.
7. .0625 HOLE MAY BE ADDED FOR FINISHING PURPOSES
8. FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX. APPLY FINISH AFTER ASSEMBLY.
9. FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX.

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE RELEASE-PW		MC
2	INITIAL RELEASE	09/10/99	P. BRAVO
3	INCORPORATED ECN 040254 0359 & 0355	07/24/12	P. BRAVO
4	INCORPORATED ECN 04025	06/02/13	P. BRAVO
5	INCORPORATED ECN 040308 0365 & 04730	11/18/13	P. BRAVO



UNINCORPORATED ECN(S)

04556

6			12	601.3072	RIVET	CR3213-6-9	
2			11	647.3917	DOUBLER		
1			10	647.3916	DEFLECTOR, UPPER HALF	△	△
1			9	647.3915	DEFLECTOR, LOWER HALF	△	△
	1		8	647.3914	BREAKAWAY TIP LONG	△	△△
		1	7	647.3913	BREAKAWAY TIP MEDIUM	△	△△
	1	1	6	647.3912	LOWER DEFLECTOR	△	△△
			5	647.3911	212 UPPER DEFLECTOR	△	△△
			4	647.3910	412 UPPER DEFLECTOR	△	△△
A/R	A/R	A/R	3	601.2045	RTV, LOCTITE 598		△
	3	2	2	601.3074	RIVET	MS20470AD 6-12	
			1		DELETED		
X				647.3903	DEFLECTOR ASSY		△
	X			647.3902	LOWER DEFLECTOR ASSY		
		X		647.3901	LOWER DEFLECTOR ASSY		
3903	3902	3901	FIND #	PART #	DESCRIPTION	MAT'L	SPEC
QTY				PARTS LIST			
NEXT ASSY (S)				ORIGINAL DATE			
647.3800				DRAWN BY			
				CHECKED BY			
				DESIGNED BY			
				CONTRACT NO.			
				UNLESS OTHERWISE SPECIFIED			
				DIMENSIONS ARE IN INCHES			
				TOLERANCES ARE:			
				3 PLACE DECIMALS ±.01			
				ANGLES ±.5°			
				SEE CHART CODE			
				B 07M16			
				SCALE NONE			
				1 SHEET 1 OF 12			

APICAL INDUSTRIES

2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

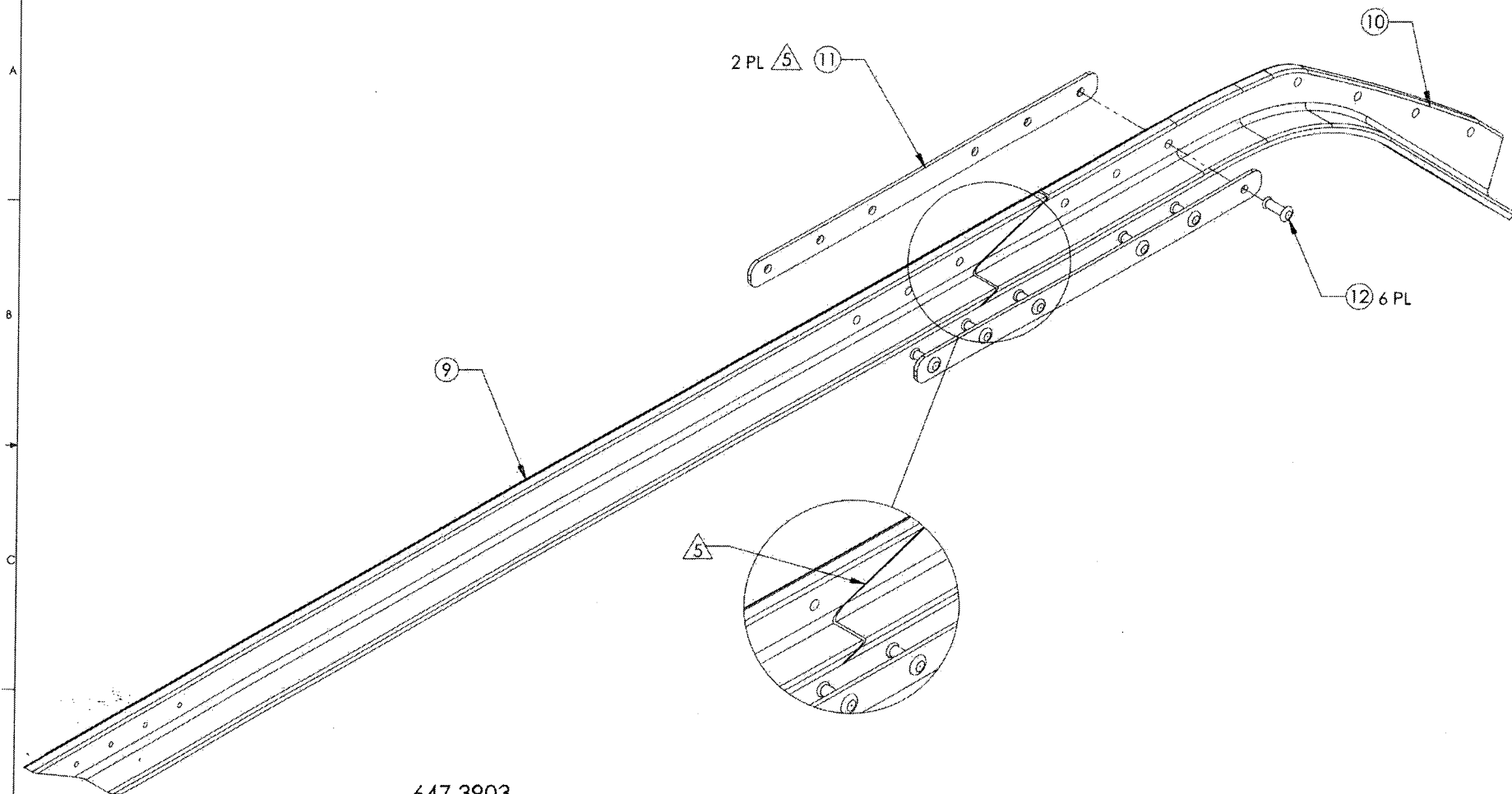
DEFLECTORS

647.3900

SCALE NONE

1 SHEET 1 OF 12

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647.3903

ORIGINAL DATE 2/20/88		APICAL INDUSTRIES	
DRAWN BY: J. B. BAKER		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: J. B. BAKER		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DESIGNED BY: J. B. BAKER		DEFLECTORS	
CONTRACT NO.		647.3900	
SHIMS OTHERWISE SPECIFIED TEMPERATURE: 400 F (100 C) 1/4" THICKNESS 2 PLACES DECKING 2001 2 PLACES DECKING 2002 ANGLES 1/4"		SIZE 1 CAGE CODE B 07ME6	REV. C
		SCALE NONE	SHEET 7 OF 12

DQA:

Date:

18/08/26



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

ERIC

Date:

April 30/15

Work Order update only ☐

Work Order: <u>430537</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. <u>647.3903</u>	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
NCR No. <u>SEE NCR 15-4798- (Pink)</u>	Scrap ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☒	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	15-03-31	120	1	Installed rivets on wrong side		Scrap / destroy & replace \$17.61 647.3915 B120739 647.3917 B130539 \$5.72	KE 3/30/15 DAS 41 9-89	38 9-89 MAR 31 2015 DAS 38 9-89 MAR 31 2015	PD 1503-31
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator ☒									
Offset/Setup									
Process									
Supplier									
Training ☒									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☒ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other